

Work Order ID 130995

March-26-15 1:34:29 PM

130995

Page 1

Item ID: D2153

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Door Prop

Stop ***NS2***

Start Date: 3/26/15 Start Qty: 24.00

24

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 1503-30

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw/Nbr	Revision Nbr								
D2153	Rev A1								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 28002 Gas Spring P/N: SL13-10 (10lb) Possible supplier: Spring Lift Corporation **Note: Do not ship by air****Allow an extra 7 to 10 business days for shipping**Material release note is required

ML5 1504-02 (36)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

36x SP15-04-8

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Inspect Test Spring is 10lb

(36)

DAS
38
S-6C

APR 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130995

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130995

Page 2

Item ID: D2153 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Prop
 Start Date: 3/26/15 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D21532- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>ST362</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89

DAS
38
9-89
APR 24 2015

APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Page 3

Item ID: D2153

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N900040100Setup Start ***NS1***

Revision ID:

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Start Date: 3/26/15 Start Qty: 24.00

24

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ APR 2 9 2015

MLJ APR 2 9 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

March-26-15 1:34:28 PM

Page 1

Work Order ID: 130995

130995

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2153P *D2153P* Door Prop		Purchased	No			130	Each	0.0000	1	24 36			
D3015-3 *D3015-3* Locknut		Manufactured	No			130	Each	74.0000	2	48			

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

56

129764

55

48238

1

130

Each

847.0000

2

48

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

68

113524

3

118206

2

m130799

63

ST269

156

m128257

156

ST271

493

m131026

493

NAS1149D0563J

Purchased

No

NAS1149D0563.J

Washer

B130908 (652)

15/04/15

DAS

36

9-89

72

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:34:28 PM

Page 2

Work Order ID: 130995

130995

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 24.00

Required Qty: 24.00

SL69-BS

Purchased

No

100

Each

98.0000

2

48

SI 69-RS

DAS

36

Ball Stud

9-89

15/04/15

Location

Loc Qty

Loc Code

GA

98

M130766

98

~~36~~ 72

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

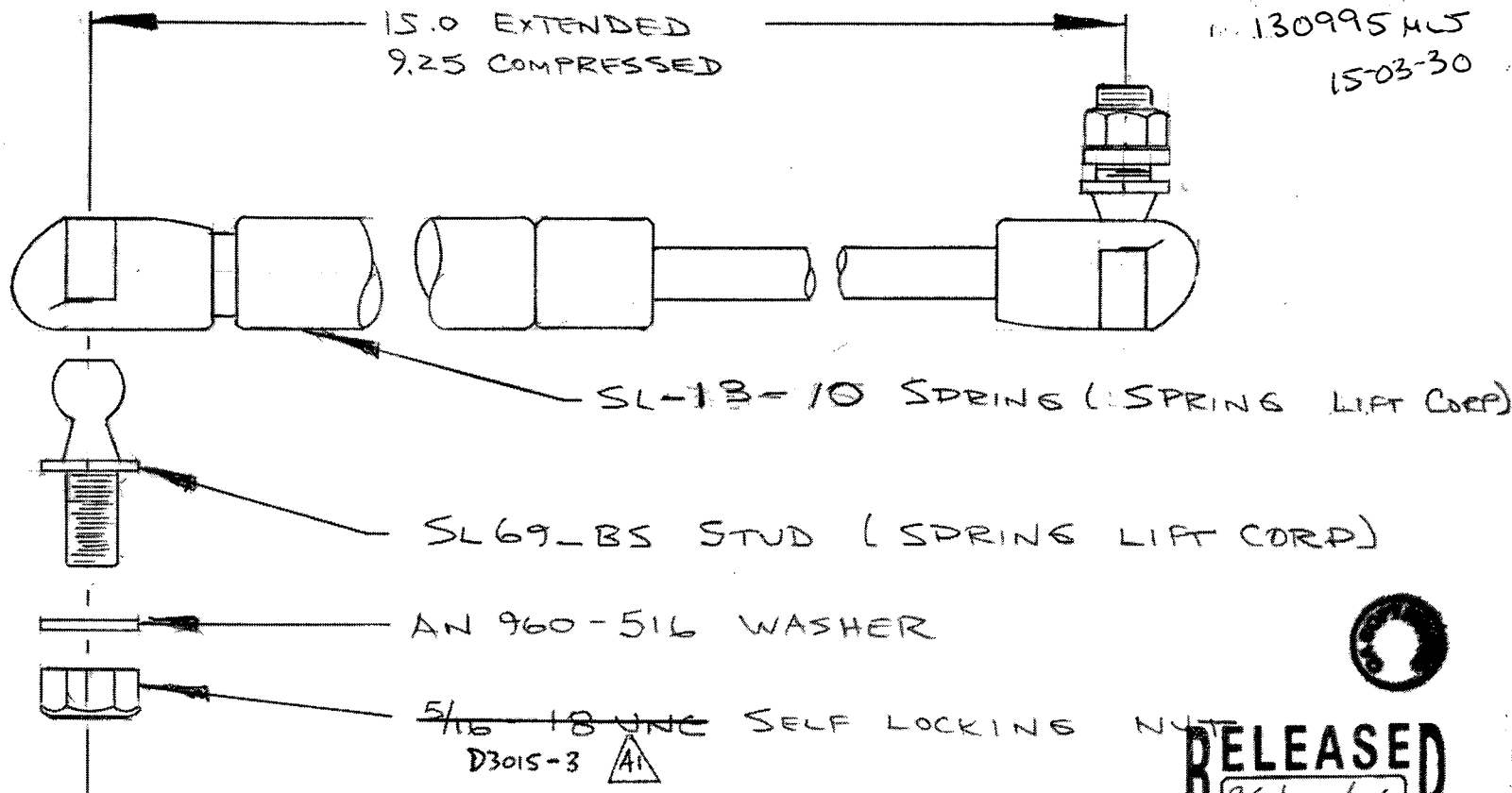
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130995 MJS
 15-03-30



RELEASED
 96/07/16

01-05-01 CHARGE TO D3015-3 SC 13-10 6441 SL32-15		A1 A CP	REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. H-HEAD NEAR SIDE F-HEAD FAR SIDE D-DIMPLE D-DIOT-NO OF SHEETS C-COUNTERSINK LENGTH DASH NO. W-SPOTWELD BASIC CODES B-HAS 20470AD BE-HAS 20426AD	PART NO. CONTRACT NO. DRAWN DESIGN STRESS CHECKED CLIENT	ITEM DATE 07.2.92	DESCRIPTION DART DART AERO ACCESSORIES INC. VANCOUVER CANADA GAS SPRING ASSEMBLY	MATERIAL SPEC/VENDOR	DZ153 SCALE 1:1 SHEET 1 OF 1	REV A
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DZ153



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28002**

Purchase Order Date 4/2/2015

PO Print Date 4/2/2015

Page Number 1 of 1

Order From :

VU-ATT001

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 616-897-2285

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2153P AS PER DWG.D2153 REV.A B130995	Door Prop	4/9/2015 Yes 4/9/2015		36.00 Each	\$4.20	\$151.20
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	4/9/2015 No 4/9/2015		1.00	\$0.00	\$0.00

Line Total: \$151.20

Line Total: \$0.00

PO Total: \$151.20

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 4/2/2015

**MotorGuide****NEVER STOP**

CUST: 68580

MST: 07530-00

TELEPHONE: 616-897-2290

COLLECT

151793240

BILL TO: DART AERO LTD.
REQ: 04/08/15

PRO NO: 290000320

SHIP VIA: FEDEX STANDARD OVERN

BOL: 00226970004667676

FREIGHT: _____

F ATTWOOD / MOTORGUIDE

R 1016 NORTH MONROE

M LOWELL, MI 49331-0200

INCOTERMS: EXW SHIPPER DOCK

T DART AERO LTD.
O 1270 ABERDEEN STREET

HAWKESBURY

ON

K6A 1K7

CRTS: 1 PO#: P028002

WGT: 12 DATE: 04/06/15

SPUR: 9

LABEL NO:

--ROUTING GUIDE INFO--

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART#	UPC	DESCRIPTION	SKU	LN	QTY	WGT
1	36	W03911	EA	SL13-10		GS SPRNG 15" EXTC 10# BL		1	36	12

Trisha
Change to fedex
SP15-048

Commercial Invoice

ECI

Ship Date: 4/7/2015

International Tracking# : 584946013183



ACI-584946013183

Purpose:

Nbr Pkgs: 1 BOX

Shipper

Consignee

CO NAME: ATTWOOD CORPORATION

CO NAME: DART AERO LTD.

CONTACT: keith swann

CONTACT:

ADDR1: 1016 N. MONROE

ADDR1: 1270 ABERDEEN STREET

ADDR2:

ADDR2:

CITY: LOWELL

ADDR3:

ST/PR: MI

CNTRY: US

CITY: HAWKESBURY

PSTL: 49331

PH#: 616 897-9241

ST/PR: ON

CNTRY: CA

IRS/EIN/EORI 380313380

PSTL: K6A1K7

PH#: 6136325200

Food Shipment: N

PN/EN:

IRS/EIN/EORI

Broker

Importer

CO NAME:

CO NAME:

CONTACT:

CONTACT:

ADDR1:

ADDR1:

ADDR2:

ADDR2:

CITY:

CITY:

ST/PR:

CNTRY:

ST/PR:

CNTRY:

PSTL:

PH#:

PSTL:

PH#:

IRS/EIN:

IRS/EIN:

MARKS/NBRS:	ECCN: EAR99	HS CODE:	8302496035	CTRY MFG:	MX
WEIGHT:	0.0 LBS	UNIT QTY:	36 EA	UNIT VALUE:	4.200000
COMMODITY VALUE:	151.20USD	LICENSE:			
EX DATE:					
DESCRIPTION:	GAS SPRING 15 EXTC 10 BL SCKT				

Date : 4/7/2015

Page Number :

1



ACI-584946013183

TOTAL SHIPMENT WEIGHT: 12.00 LBS

TOTAL COMMODITY VALUE:

151.20

FREIGHT AMOUNT:

0.00

INSURANCE AMOUNT:

0.00

OTHER AMOUNT:

0.00

TOTAL INVOICE:

151.20

TERMS OF SALE:

DDU

These commodities, technology or software were exported from the United States in accordance with the Export Administration regulations Diversion contrary to United States is prohibited.

COMMENTS:

I declare all information in this invoice to be true and correct.

keith swann

ATTWOOD CORPORATION

4/7/2015